*

Work Order ID 59503

Friday, June 04, 2010 3:01:44 PM

QC

Quality Control



Page 1

-4

Item ID: D4005-041 Accept Setup Start **Revision ID:** Stop Item Name: Fwd Floor Gutter **Start Date:** 6/4/2010 Start Qty: 1.00 **Cust Item ID: Required Date: 6/10/2010** Req'd Qty: 1.00 **Customer:** Reference: Run Start Approvals: Date/// **Tooling:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Number Qty Stamp **Draw Nbr Revision Nbr** D4005 Α 100 0.00 B10-6-10 Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg (D4005-13) Dwg Rev: 2024 Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00

0.00

Memo

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W/O:			WO	RK ORDER CHAN	GES					
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	jory:	NCR: Y	es No	DQ/	A :	_ Date: _	
	Res	olution:	Disposition	i:	QA: N/0	Clos	ed:		Date:	
NCR:			WORK ORDE	R NON-CONFORM	IANCE (N	CR)				
DATE	STEP	Description of NC			ction B		Verific	ation	Approval	Approval
	J	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Section C		Chief Eng	QC Inspector
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Work	Order	ID	59503

Friday, June 04, 2010 3:01:44 PM



Page 2

Item ID:

D4005-041

Accept

Setup Start

Revision ID:

Item Name:

Fwd Floor Gutter

Start Date:

6/4/2010

Start Qty: 1.00

Required Date: 6/10/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

QC:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Start Run

Stop

Stop



Sequence ID/

Work Center ID

120

OC

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Memo

0.00

& volocitio

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

130

Brake NC

Brake NC

Bend as per dwg

0.00

0.00

SB 10/06/10

140

QC5- Inspect part completeness to step on W/O

Bend D4005-13 as per Dwg

0.00

Quality Control

Memo

	-													
W/O:			WORK ORDER CHANGES											
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NCR:			WORK ORI	DER NON-CONFORM	ANCE	(NCR)							
DATE	STEP	Description of NC		· · · · · · · · · · · · · · · · · · ·	ion B		Verific	ation	Approval	Approval				
DAIL	JIEF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector				
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Work Order ID 59503

Friday, June 04, 2010 3:01:44 PM



Page 3

Item ID:

D4005-041

Accept



Setup Start



Revision ID:

Item Name: Fwd Floor Gutter

Required Date: 6/10/2010

Start Date:

6/4/2010

Start Otv: 1.00

Req'd Oty: 1.00



Cust Item ID: Customer:

Reference:

		_	
Δn	nra	vals:	
CYD	DI O	vais.	

QC:

Process Plan:

Operation

Description

Date:

Weld per dwg A/R Aluminum rod Batch: M1/2860 0.00

Tooling:

Date:

Date:

de 10.08.30 -1

Run

Start

Stop

Stop



Date:

SPC (Y/N):

Set Up/

Run Hours

Tool ID

Tool # Plan

Code

Accept

Qty

Reject Otv

Insp. Reject Number Stamp

Work Center ID 141

Large Fab

Sequence ID/

Large Fab

Memo

0.00

1- Weld D4003-13 tube to angle as per dwg D4005

2- grind flush as per dwg

142

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

D 10.08.31 (D

143

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

	-								_
W/O:			W	ORK ORDER CHANG	ES				
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	R	esolution:	Disposition	on:	_ QA: N/C (Closed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC			ion B	Verific	ation	Approval	Approval
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Work Order ID 59503

Friday, June 04, 2010 3:01:44 PM



Page 4

Item ID:

D4005-041

Accept



Setup Start



Revision ID:

Fwd Floor Gutter Item Name:

Start Date:

6/4/2010

Start Qty: 1.00

Required Date: 6/10/2010

Req'd Qty: 1.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:_____

Tooling:

Date:

Run

Start

Stop



Date:_____

SPC (Y/N):

Date:

Stop



Sequence ID/ **Work Center ID**

150

HandFinish

Operation Description

Chemical Conversion Coat per QSI005 4.1

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject **Qty**

Reject Number

10 08 37

Insp.

Stamp

Hand Finishing

160

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

m 42388

Memo

Start Time: Oven Temperature: Finish Time: 10 180 0.00 Bl 10-9-10

0.00

170

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

10/09/13

	-									
W/O:			WO	RK ORDER CHANG	ES				•	
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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DATE	STEP	Description of NC			tion B	Verific	ation	Approval	Approval	
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Work Order ID 59503

Fridav, June 04, 2010 3:01:44 PM



Page 5

Item ID:

D4005-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Fwd Floor Gutter

Start Date:

6/4/2010

Start Otv: 1.00

Required Date: 6/10/2010

Req'd Qty: 1.00



Cust Item ID: Customer:

Tool ID

Reference:

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	nr	MA	vol	
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OC:

Process Plan:

Memo

Memo

Date: _____

Date: Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Run

Start



Stop

Sequence ID/ Work Center ID

190

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location: // O

0.00

0.00

Tool # Plan

Code Otv

Accept Reject Otv

Reject

Insp. Number Stamp

200

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

10/09/14 A) M10-9-13 J

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W/O:			WO	RK ORDER CHANG	GES .				
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Picklist Print

Friday, June 04, 2010 3:01:48 PM

Work Order ID: 59503

Parent Item: D4005-041

Parent Item Name:

Fwd Floor Gutter

Comments:

IPP rev A 10.01.21 new issue Prelim EC verified by:DD 10.05.03 as per ECN10-562 DD verified by:EC

IPP Rev:B

Start Date: 6/4/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

	corocios as per Be	1110 202 DD 1	criffed b	,.LC								
Component Item ID/ Item Name M2024T3S.040	Replacement Item ID	Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID 100	Unit of Measure sf	Qty on Hand 436.0000	 Total Otv 0.442105	Qty Issued	Date Issued	Status
2024-T3 .040 sheet									V	B10-6.	-10	
				Location		Loc (<u>Qty</u>	Loc Code			_	
				MAT			96				2	
					114415		96					
				MAT22			340					

110305 102.2 111786 15.5 112291 32 112331 52 113162 138.3

Manufactured No 141 Each 1.0000

Location Loc Code Loc Qty **ENG** 55857

Fwd Fuel Gutter Line

D4003-13

110303

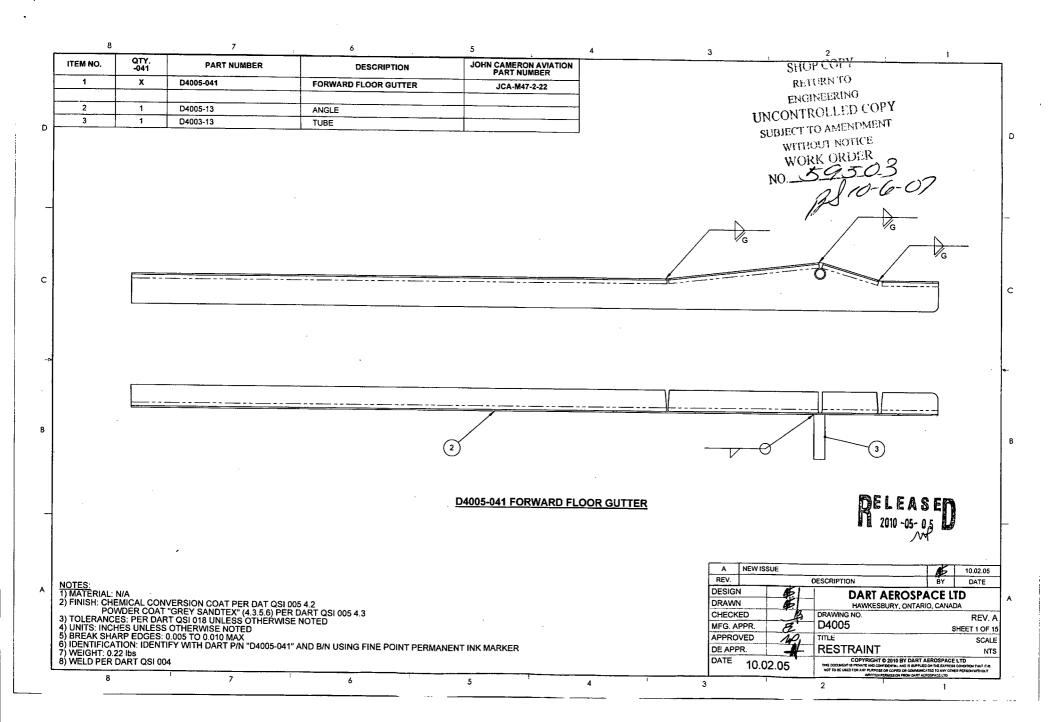
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DART AEROSPACE LTD	Work Order:	59503
Description: FWD FLOOR GUTTER	Part Number:	D4004-041
Inspection Dwg: 74005-(3 Rev: A		Page 1 of 1

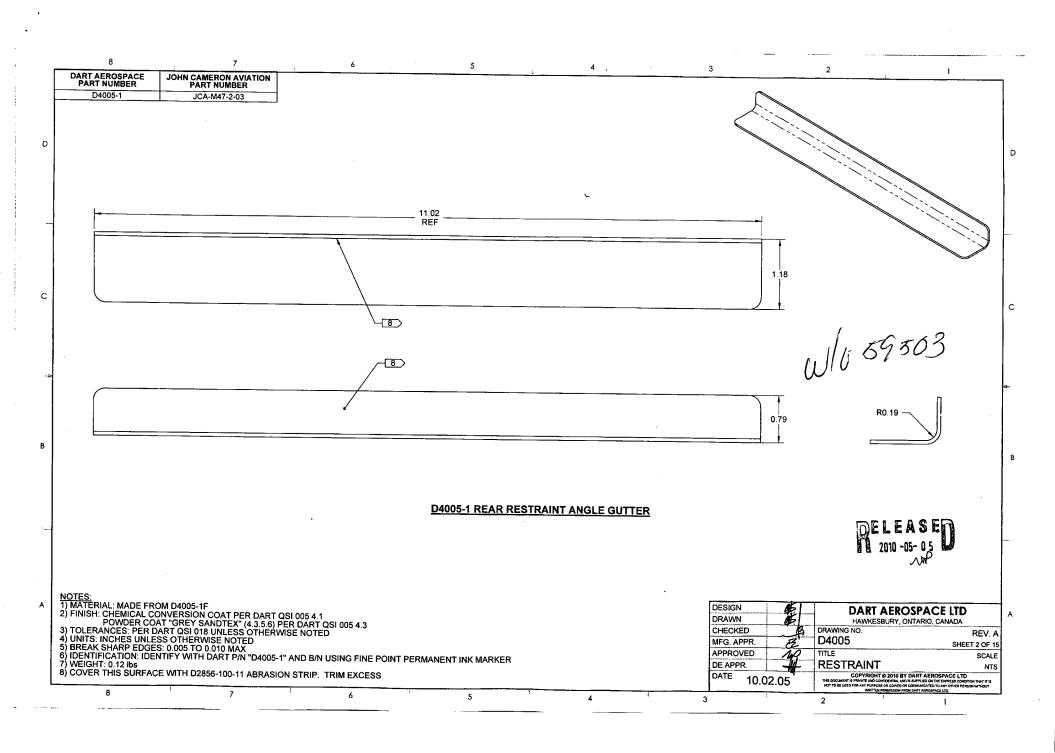
FIRST ARTICLE INSPECTION CHECKLIST

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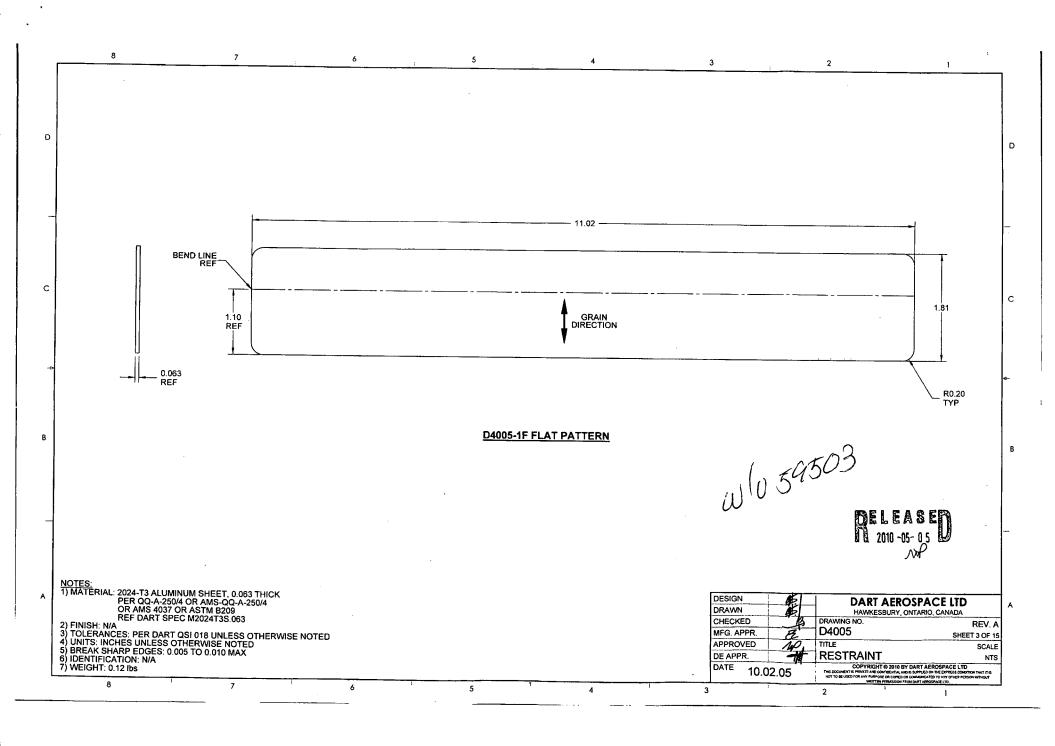
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	Date:	10-6-10	Date: 10/06/10	Date:	N/A
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Rev	Date	New Issue		KJ/JLM	1



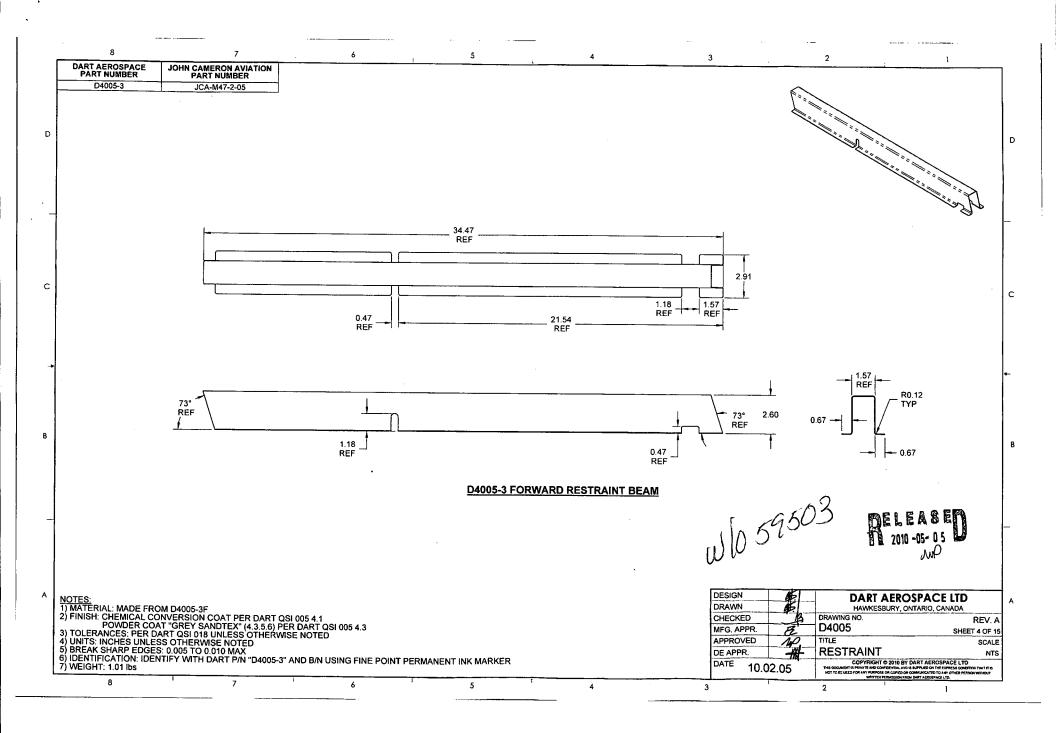
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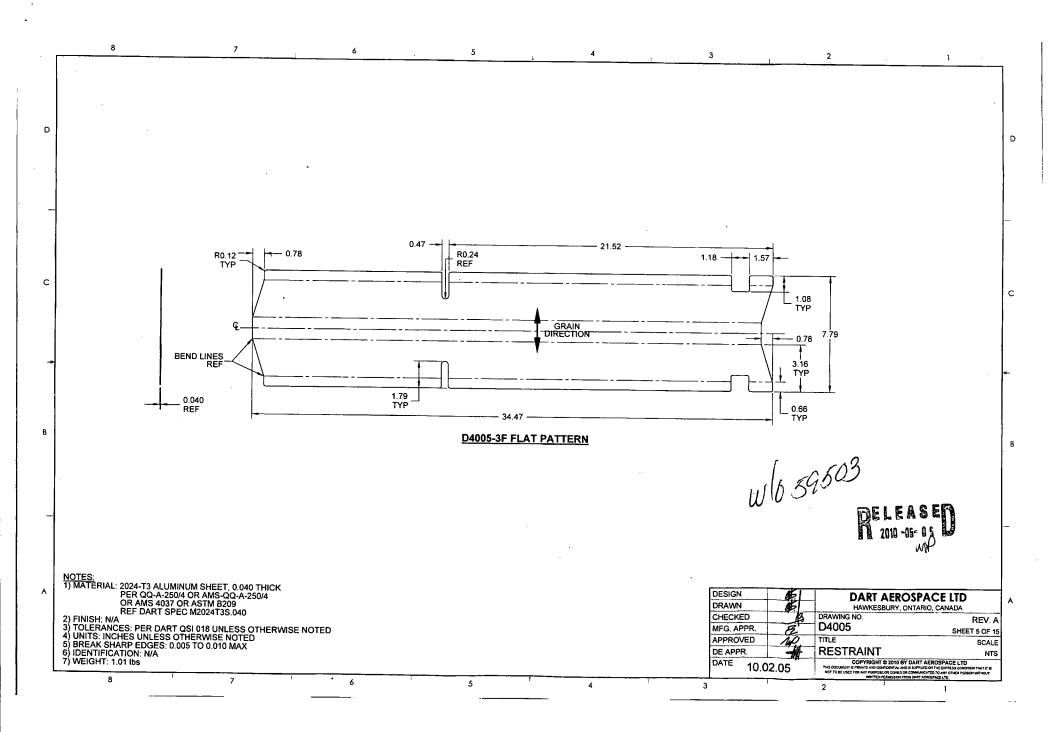
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3 DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4005-5 JCA-M47-2-06 D D С С \bigcirc \bigcirc 1.00 R0.12 wlo 59503 0.98 REF **D4005-5 ANGLE** DESIGN DART AEROSPACE LTD NOTES:
1) MATERIAL: MADE FROM D4005-5F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4005-5" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.01 lbs DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D4005 MFG. APPR. SHEET 6 OF 15 APPROVED TITLE SCALE DE APPR. RESTRAINT NTS COPYRIGHT @ 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE WHO CONFEDENCE, WHO IS SUPPLIED ON THE EXPRESS CONDITION IN HIS IT IS
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D R0.12 TYP GRAIN DIRECTION BEND LINE REF 1.93 Ø0.098 2 PL 0.96 REF 0.43 w/059503 0.040 --- 0.43 ---- 0.28 REF **- 0.98 -D4005-5F FLAT PATTERN**

D

С

NOTES: 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC M2024T3S.040 REF DART SPEC M2U24135.040
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

DESIGN	6	DART AEROS	DART AEROSPACE LTD					
DRAWN	45	HAWKESBURY, ONTA	ARIO, CANADA					
CHECKED	B	DRAWING NO.	REV. A					
MFG. APPR.	臣	D4005	SHEET 7 OF 15					
APPROVED	16.	TITLE	SCALE					
DE APPR.		RESTRAINT	NTS					
DATE 10.0	2.05	COPYRIGHT © 2010 BY DAR THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS THE NOT TO BE USED FOR ANY PURPOSE OR COMED OR COME WATETER PERMISSION FROM DAR	PUED ON THE EXPRESS CONDITION THAT IT IS KINICATED TO ANY OTHER PERSON WITHOUT					

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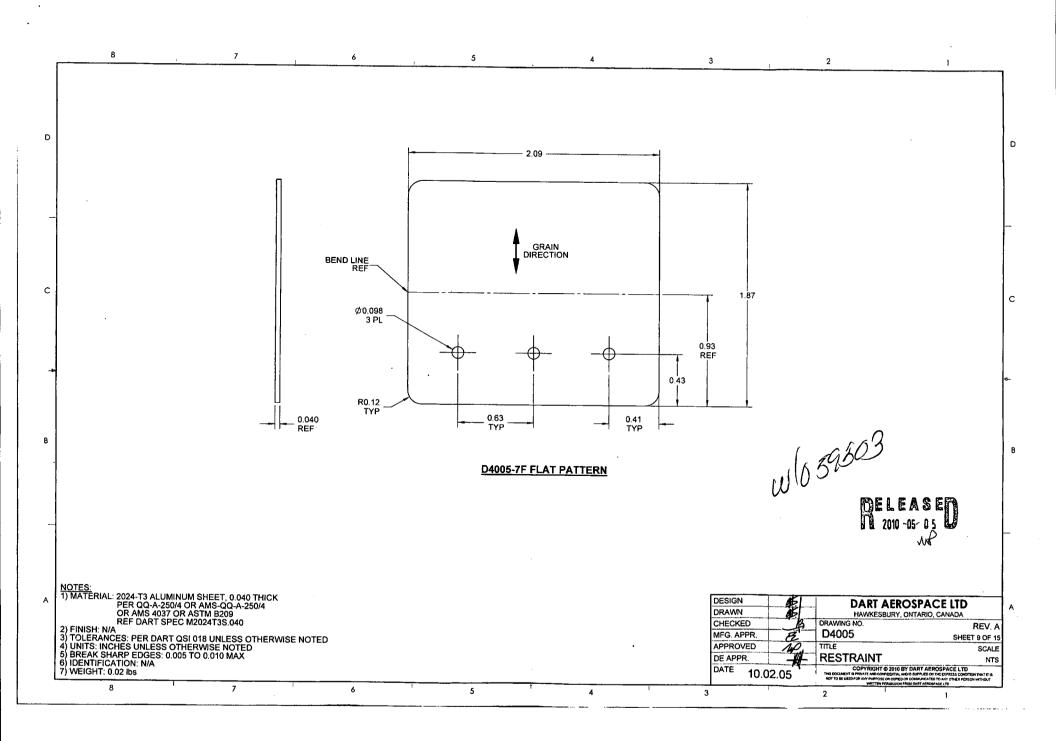
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W/O:			WO	RK ORDER CHANG	ES				
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5 3 2 DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4005-7 JCA-M47-2-07 D D 0.98 0.98 R0.12 2.09 REF w 10 59503 D4005-7 ANGLE MADE FROM D4005-7F DESIGN DART AEROSPACE LTD NOTES:
1) MATERIAL: MADE FROM D4005-7F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4005-7" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.02 lbs DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4005 MFG. APPR. SHEET 8 OF 15 APPROVED SCALE RESTRAINT DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL MIGHS SUPPLIED ON THE EXPRESS CONDITION TO TO BE USED FOR ANY PURPOSES OR CONFIDENTIAL MIGHS SUPPLIED FOR THE EXPRESS CONDITION TO THE USED TO BE USED FOR ANY PURPOSES OR CONFIDENTIAL TO THE ANY PURPOSES. DATE 10.02.05 2

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	Re	esolution:	Disposition	າ:	QA: N/C	Closed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC			tion B	Verif	ication	Approval Chief Eng	Approval
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3 DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4005-9 JCA-M47-2-08 D С 108° 0.95 R0.12 W/0 59503

PELEASED

2010-05-05 **D4005-9 ANGLE**

NOTES:
1) MATERIAL: MADE FROM D4005-9F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4005-9" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.01 lbs

DESIGN	45	DART AEROS	SPACE LTD				
DRAWN	A 5	HAWKESBURY, ONTARIO, CANADA					
CHECKED	B	DRAWING NO.	REV. A				
MFG. APPR.	图	D4005	SHEET 10 OF 15				
APPROVED	10	TITLE	SCALE				
DE APPR.	-13-	RESTRAINT	NTS				
DATE 10.0	2.05	COPYRIGHT © 2010 BY D	SUPPLIED ON THE EXPRESS CONDITION THAT IT IS				

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W/O:	<u> </u>		wc	ORK ORDER CHANG	FS							
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
							:					
Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes							
	Res	olution:	Disposition	Disposition: Q/			QA: N/C Closed: Date:					
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (NC	R)	· · · · · ·	··· •				
DATE	STEP	Description of NC	Corrective Action Section B			Verific	cation	Approval	Approval			
	Section A		Initial Chief Eng	Action Description Chief Eng	Sign Date			Chief Eng	QC Inspector			
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R0.12 0.98 TYP GRAIN DIRECTION BEND LINE REF 1.91 0.96 REF 0.43 0.040 Ø0.098 REF -0.28 --- 0.43 ---2 PL

w (0 59303

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D4005-9F FLAT PATTERN

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NOTES: 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC M2024T3S.040

2) FINISH: NIA:

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NIA

7) WEIGHT: 0.01 lbs

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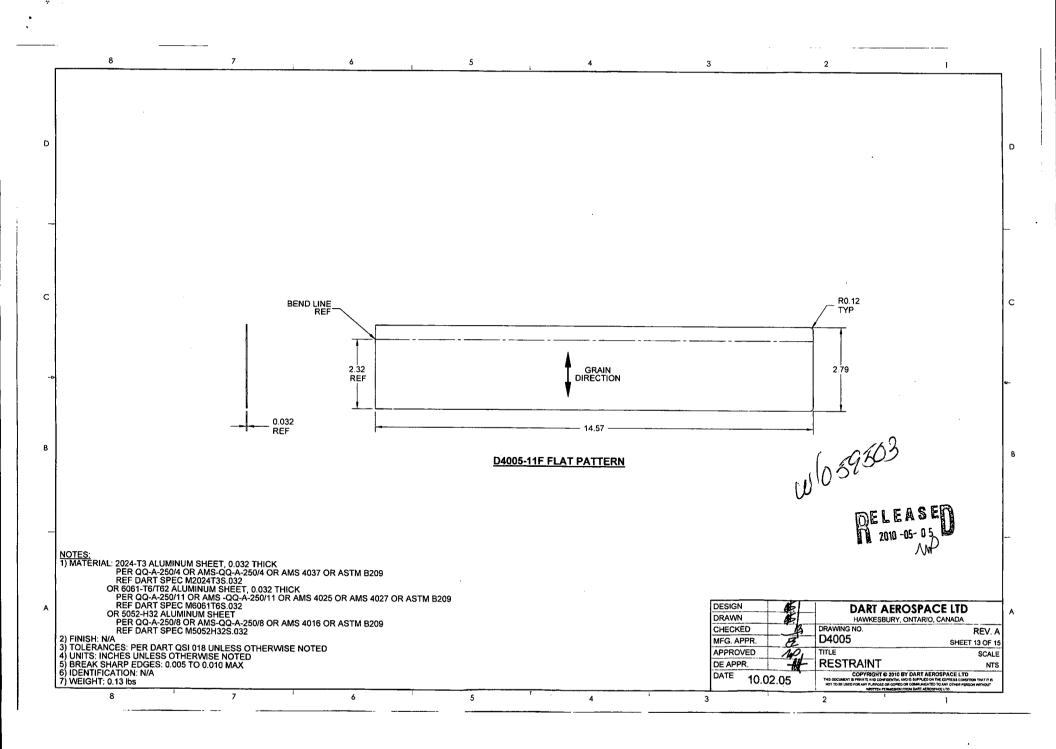
DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN CHECKED DRAWING NO. REV. A D4005 MFG. APPR. **SHEET 11 OF 15** TITLE APPROVED SCALE RESTRAINT DE APPR. NTS DATE 10.02.05 COPYRIGHT © 2010 BY DART AEROSPACE LTD
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W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	PROCEDURE CHANGE				te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
								:		
Part No	•	PAR #:	Fault Categ	ory:	_ NCR: Ye	es No	DQA:	Date: _		
	Re	solution:	Disposition	l:	_ QA: N/C	QA: N/C Closed: Date:				
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	CR)				
DATE	STEP	Description of NC	Corrective Action Section I			v	erification	Approval	Approval	
	Section A		Initial Action Descript Chief Eng Chief Eng		Sign & S		Section C	Chief Eng	QC Inspector	
									-	

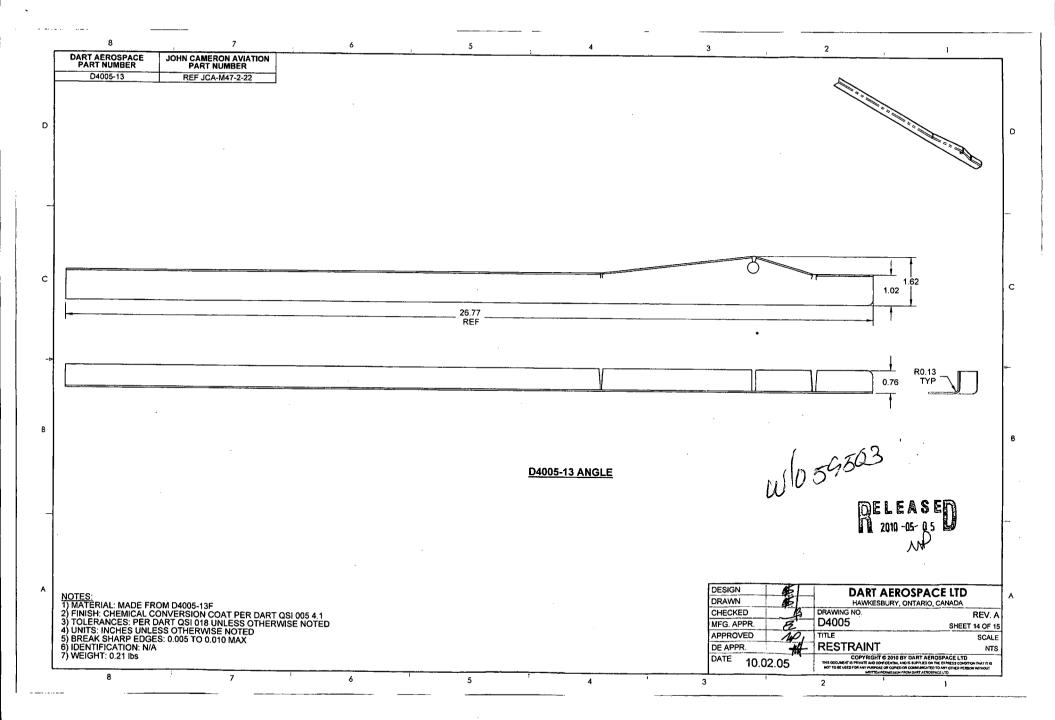
DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4005-11 JCA-M47-2-12 D 2.36 C 14.57 REF R0.10 --0.51 w 1059303 **D4005-11 FINISHING STRIP** DESIGN **DART AEROSPACE LTD** NOTES:

1) MATERIAL: MADE FROM D4005-11F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4005-11" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.13 lbs DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4005 MFG. APPR. SHEET 12 OF 15 TITLE APPROVED SCALE RESTRAINT DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
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W/O:			WC	ORK ORDER CHANG	SES						
DATE STEP		PROCEDURE CHANGE			Ву	Date	ate Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No:		PAR #:	Fault Cate	gory:	_ NCR: Yes	Date:					
Resolution:			Disposition: Q			QA: N/C Closed: Date:					
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	R)					
DATE	STEP	Description of NC	Corrective Action Section Initial Action Description		tion B Sign		cation	Approval	Approval		
		Section A	Chief Eng	Action Description Chief Eng	Date		ion C	Chief Eng	QC Inspector		
											



W/O:	<u> </u>		WO	RK ORDER CHANG	250					
DATE	STEP	PR	OCEDURE CHAN		B	/	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory:	NCR: Y	es N	lo DQ /	4:	Date:	
	Res	olution:	Disposition: Q			QA: N/C Closed:				
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	CR)				
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descr		Section B Sign &		Verification Section C		Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng	L	ate				
						; 				



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W/O:			WC	ORK ORDER CHAN	GES			· · · · · · · · · · · · · · · · · · ·	
DATE	STEP	PR	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						, <u></u>	<u> </u>		
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
	Re	esolution:	Dispositio	QA: N/C C	osed:	Date: _			
NCR:			WORK ORDI	ER NON-CONFORM	IANCE (NCF	?)			
DATE	STEP	Description of NC			ction B	Verific	cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		on C	Chief Eng	QC Inspector
					ł				

BEND LINE BEND LINE REF 9.13 - 9.08 4.12 R0.38 TYP BEND LINE BEND LINE 0.7Ó REF, TYP - 1.88 - 1.87 GRAIN DIRECTION 1.67 0.97 1.25 REF 0.040 REF Ø0.375 --4.00 -R0.20 26.77 -

D4005-13F FLAT PATTERN

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NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
2) FINISH: N/A
2) TOLEDANOES BED DADE SOLETA

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.21 lbs

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DESIGN DRAWN		DART AEROS HAWKESBURY, ONT			
CHECKED	B	DRAWING NO.	REV. A		
MFG. APPR.	E	D4005	SHEET 15 OF 15		
APPROVED	10,	TITLE	SCALE		
DE APPR.	-#	RESTRAINT	NTS		
DATE 10.0	2.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND DOCUMENT IS EXPRESS ON THE EXPRESS CONTINUE THAT IT IS NOT TO BE USED FOR ANY PURPOSE ON COMPOSITION TO NAMY OTHER PERSON WITHOUT			

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W/O: WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

		PAR #:	Fault Category: Disposition:			: Yes i	No DQ	QA: Date:		
		esolution:				N/C Clo	sed:	··	Date:	
NCR:		,	WORK ORD	ER NON-CONFORM	ANCE	(NCR				
DATE	STEP Description of NO Section A		Initial Action Descripti		etion B	Sign &		cation on C	Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng		Date				
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